<b>Work Order</b> July-19-12 11:09.			*875	<b>04</b> *					Page 1	
tem ID: D	04020-3		Accept	*N9000	140100	)* s	Setup Star	171	S1*	_
	Mesh (350 Basket Short, Base)  /10/12	*7* *7* (	Txa	Cust Item ID	:		Stop	IN.	S2*	
Approvals:	Process Plan: MLJ	Date: 12/07/	Tooling:	Date	);	Ŗ	Run Star	17	R1*	
	QC:	Date:	SPC (Y/N):	Date			Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description	- S	Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision Nbr									
D4020	A									
*100 *100* Shear Shear	FLOW WATER JET  Memo 1-Cut mesh necessary)	n at 56.00" (when mesh is	0.00 0.00 on D4017-041 trim mesh to	finish size if	(12.12.6	1x 24				
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimension  Memo	ns to drawing	0.00		SS	12.1	2.24			
*130	Identify as per dwg & S	tock Location: What	7 0.00 CpC	12.12.24		/ĸ				
Packaging	Memo		0.00	, , , , , , , , ,						

Packaging

										DQA:	Date:	1.
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	MANCE / UPD	ATE			•
								-		QA Closed:	Date:	
Work Orde	or.	_			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				· · · · · · · · · · · · · · · · · · ·	Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier	
			,	ı		لــــا						T
Root					ption of work order update	1	nitial	Actio		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data												
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Process												
Supplier				ł								
Training												
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					F	AUL	T CATE	GORY	<u> </u>			
Landir	ng Gear			_	General					•		7
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde July-19-12 11:0								Page 2				
Item ID: Revision ID: Item Name:	D4020-3 Mesh (35	0 Basket Short, Base)		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	ı	S1* S2*
Start Date: Required Date: Reference:	7/10/12 8/03/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	i	Cust Item I Customer:	D:						
Approvals:	Process QC:		Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	!/	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	ot Re Qt	•	Reject Number	Insp. Stamp
*14 <b>0</b> *		Memo		0.00				<u> </u>		2/1	17	77

Memo

Quality Control

7//-/-MF 12-27

											DQA:	Date	::	
NCR: Y	es /	No				WORK ORDER NON-O	CON	NFORI	MANCE / UP	DATE				
						<b>.</b>					QA Closed:	Date	:	
Work Orde	or.					DISPOSITION	1			AGAINST DI	EPARTMENT	/PROCESS		
Work Grad						Rework	1		Skid-tube	Crosstube	7	Water Jet	]	Engineering
Part N	No					Scrap	]		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	_	Other
NCR N	No					Work Order Update	J		Large Fab	Composite	_	Supplier		
Root	1				Descri	tion of work order update	-1	nitial	Ac	tion	Sign &		I	
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification		QC Inspector
Doc/Data														
Equip/Tooling														
Operator							ļ							
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	-					F	AUL	T CATE	GORY					
Landii	ng Gea	r				General					_	_		
Bending						Bend		Grain			Ovalized		_]Pr	ressure/Forced
Centre Not Concentric to O/S					o/s	BOM/Route		Hardwa	are		Over/Unde	tolerance	Te	emperature/Cure
	Cracks					Broken/Damaged	Inspection Incomplete				Part Incorre	ct	$\neg$ <sub>w</sub>	/eld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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## **Picklist Print**

July-19-12 11:09:11 AM

Work Order ID:

87504

Parent Item:

D4020-3

Parent Item Name:

Mesh (350 Basket Short, Base)

**Start Date:** 7/10/12

Required Date: 8/03/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by:EC

IPP Rev:B as per dwg revA 10.03.15

verified by:EC

	•												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		ate Sta	atus
M304EX0.75-16F		Purchased	No			100	sf	609.7005	19.1516	40.319158	100	12.12	01/
Expanded Metal Flat SS									0.0				77
				Location	•	Loc Oty	Lo	c Code		M12385	55 —	<b>&gt;</b> -2	0.15
				WA035		609.7004637							
						102 002 (							

A035 609.7004637

117197 102.9036
120917 50.88673
121521 0.00013372
122080 112.72
122138 23.19
122315 320

NCR:	·												
											QA Closed:	Date:	·:· · · · ·
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	•					Rework	]		Skid-tube	Crosstube	_	Water Jet	Engineering
Part f	۷ο.					Scrap			Machining	Small Fab	1	d. Eng. Coor.	Quality
NCR f						Use-as-is Work Order Update	-		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
NCKI	VO.				<u></u>	work Order opdate	ا ل		raige rab[]	Composite	l	3dphiei	] [_]
Root		,			Descri	ption of work order update	Π	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling									4				(8)
Operator													
Material													
Setup		B											
Other													
Process													
Supplier											i '		
Training				1 .									
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (	Gear				General	_	,		<del></del>	<b>-</b>		7
		Bending				Bend	L	Grain			Ovalized	<u></u>	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.					Burrs	L	Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance		Part Moved		
	Heat Treat					Countersink		Mislabe	eled		Positioned V	Vrong	_
ļ		Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
	Torque Waves in Extrusion					Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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D SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 87504 MCJ 12/07/20 15.13 15.61 19.52 -(SEE D4020-1 FOR LENGTH) D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A NEW ISSUE A 10.03.04 REV. DESCRIPTION BY DATE DESIGN AJS **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 6) IDENTIFICATION: N/A MFG. APPR. SHEET 1 OF 4 6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. DATE 10.03.04

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CO	NFOR	MANCE / UPDATE				
						,					QA Closed:	Date:	
Work Orde	or:					DISPOSITION			AGAI	NST DE	PARTMENT	PROCESS	
Part f	- No					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosst  Machining Small  noforming Finis  Large Fab Compo	Fab	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		22											
							AUL	T CATE	GORY				
Landi					_	General		1	÷	_	1		٦
<4	$\vdash$	Bending Centre No	ot Concer	ntric to	o/s	Bend BOM/Route	-	Grain Hardwa	are	-	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	П	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	$\Box$	Crushed/	Crimped.			Burrs		Instruct	tions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	П	Cuffs				Contamination		Mainte	enance		Part Moved	<u> </u>	_
	П	Joat Tros	+			Countersink		Miclaho	alad		Positioned \	Mrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

**Drill Holes** 

Drawing

Finish

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D4020-5: 95.25 D4020-7: 56.00 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66

9 D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 Ibs APPROX

-7: 4.49 lbs APPROX

8

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm\,0.06$ .

DESIGN AJS **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND COMPENTIAL AND IS SEPPLED ON THE DOTTESS COMMITTO
TO BE USED FOR NAM PROPOSE OF COMMISSION TO THE PROPOSE
WHITTEN PROMISSION FOR MOUNT AND OWN AND OWN THE DATE 10.03.04

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Work Orde	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part N	- No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite				Rec/Stor	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other	
Root						ption of work order update	ł	nitial		tion		Sign &		Ì	
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	_	Date	Verification	<u> </u>	QC Inspector
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Landi	ng G	iear				General		_		_					•
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		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct	L	Weld
100	Crushed/Crimped. Burrs					Burrs	Instructions Incomplete/Unclear				Part Lost/M	issing		Wrong Stock Pulled	
	Cuffs					Contamination				1	Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

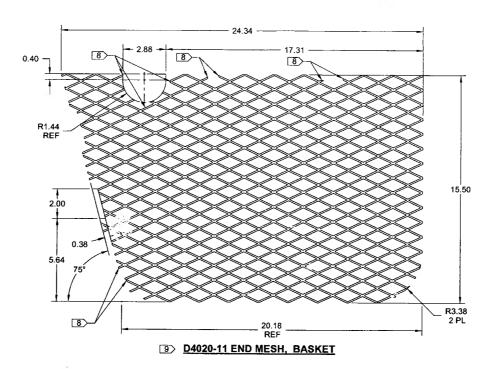
Cut Too Short

**Drill Holes** 

Drawing

Finish

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NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT 1 22 Ibe

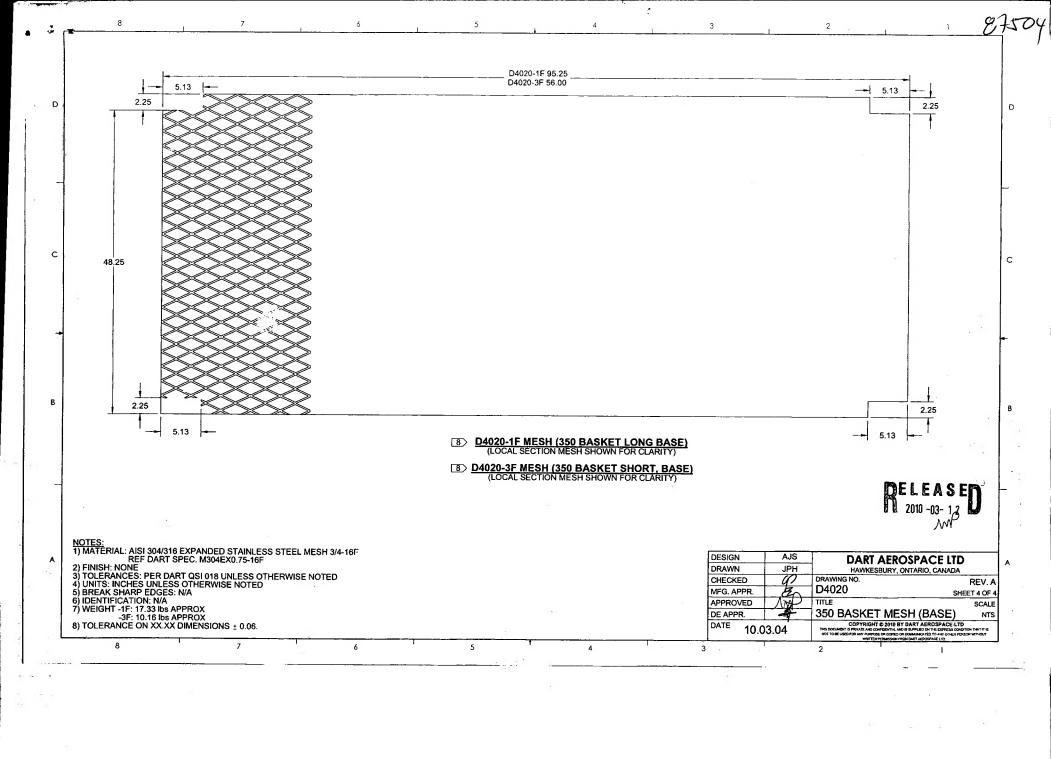
6) IDENTIFICATION. 1974
7) WEIGHT: 1.22 IDE
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED 350 BASKET MESH (BASE) DE APPR. DATE 10.03.04

NCR:	Yes	/	No

												DQA:	Date:	
NCR:	'es	/ No					WORK ORDER NON-C	ON	<b>IFORN</b>	ANCE / UPD	ATE			-
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Mark Orde							DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Vork Orde	er.				<del>.</del>		Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
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Root					Desc	•	ition of work order update		nitial	Actio		Sign &		
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
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		Crushed/C	Crimped.		1		Burrs		ł	ions Incomplete/Ur	nclear	Part Lost/M	issing	Wrong Stock Pulled
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	<b>├</b>						Countersink		Mislabe		1	Positioned V		٦
		Inspection		Tube			Cut Too Short	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Misread		L L	Power Loss/	Surge	Other
Ripples in Bend Drill Holes						_	Offset							
	Torque Waves in Extrusion Drawing						$\vdash$	ł	Calibration					
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	Wave/Twist in Tube Folio								Outside Dimensions					

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		, A								3	DQ	A:	Date:	
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Work Orde							DISPOSITION			AGAINST [	EPARTMEN	T/PROCESS	<b>;</b>	
WOIK OIGE	-						Rework	7	*	Skid-tube Crosstube	7	Water	Jet	Engineering
Part N	lo.						Scrap	1		Machining Small Fab	_   թ	rod. Eng. Co	-	Quality
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NCR N	lo.						Work Order Update	1		Large Fab Composite		Supp	lier 🔙	
Root					Des		otion of work order update	i	nitial	Action	Sign &	,		
Cause	$\dashv$	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description	Date	Verifica	ation	QC Inspector
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upplier			1											4.5
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		Cracks					Broken/Damaged	_	1	ion Incomplete	Part Incor		<u> </u>	Weld
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	_	Cuffs					Contamination	-	Mainte		Part Mov			¥- 6
		Heat Treat Countersink					-	Mislabe	}	Positione	_		1045-	
	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					$\vdash$	Misread	1	Power Lo	ss/Surge	L	Other		
							-	Offset	Calibration					
	Turning Sequence Finish						Drawing Sinish	-	4	Sequence				
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